

Work Order ID 64823

Friday, December 17, 2010 8:03:53 AM



Page 1

Item ID: D3639-2

Accept



Setup Start



Revision ID:

Item Name: Doubler

Stop



Start Date: 12/16/2010 Start Qty: 6.00



Cust Item ID:

Required Date: 1/19/2011 Req'd Qty: 6.00



Customer:

Reference:

Approvals:

Process Plan:

M

Date: 10-12-17

Tooling:

Date:

Run Start



QC:

Date:

SPC (Y/N):

Date:

Stop



Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Tool ID

Tool #

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

Draw Nbr

Revision Nbr

D3639

Rev A

100

0.00



FLOW WATER JET

Waterjet

Memo

0.00

FLOW CNC Waterjet

2074 .050

1-Cut as per Dwg D3639

Dwg Rev: *A*

Prog Rev: *A*

2-Debur if necessary

B11-1-3

8

110

0.00



QC2- Inspect parts off machine FAI/FAIB

QC

Memo

0.00

Quality Control

B11-1-3

120

0.00



QC8- Inspect parts - second check

QC

Memo

0.00

Quality Control

Sulob/03

KS

W/O:		WORK ORDER CHANGES					
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DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
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NOTE: Date & initial all entries

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Page 2

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Customer:

Reference:

Approvals:

Process Plan:

Date:

Tooling:

Date:

Run Start

QC:

Date:

SPC (Y/N):

Date:

Stop

Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Tool ID

Tool #

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

140



Brake NC

Brake NC

NC BRAKE

Memo

Form as per Dwg D3639

0.00

0.00

SB 11/01/04

8

150



QC

Quality Control

QC5- Inspect part completeness to step on W/O

Memo

0.00

0.00

S 11/01/04

8

-2

160



HandFinish

Hand Finishing

Chemical Conversion Coat per QSI005 4.1

Memo

0.00

0.00

=) M 11/01/05

8

W/O:		WORK ORDER CHANGES					
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Page 3

Item ID: D3639-2

Accept



Setup Start



Revision ID:

Stop



Item Name: Doubler

Start Date: 12/16/2010 Start Qty: 6.00



Cust Item ID:

Required Date: 1/19/2011 Req'd Qty: 6.00



Customer:

Reference:

Run Start



Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____

Stop



QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
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170

QC3- Inspect Part Finish

0.00



QC

Memo

0.00

Quality Control

8 BR 11-01-5.

180

Identify as per dwg & Stock Location 244

0.00



Packaging

Memo

0.00

Packaging

11/21/06 (8)

190

QC21- Final Inspection - Work Order Release

0.00



QC

Memo

0.00

Quality Control

OK 11/01/06

MF
11-01-06

W/O:		WORK ORDER CHANGES					
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NOTE: Date & initial all entries

Picklist Print

Friday, December 17, 2010 8:03:58 AM

Page 1

Work Order ID: 64823

Parent Item: D3639-2

Parent Item Name: Doubler



Start Date: 12/10/2010

Required Date: 1/19/2011

Start Qty: 6.00

Required Qty: 6.00

Comments: IPP Rev:A New Issue 07-07-20 JLM Verified By:EC IPP Rev:B
remove c'sink DD 10.04.13 verified by:EC

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
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M2024T3S.050

Purchased

No

100

sf

92.3847

0.239

1.509474

2



11-1-3

2024-T3 .050 sheet

Location

Loc Qty

Loc Code

MAT22

92.3847

111381

11.89

113189

0.3947

114968

80.1

114968

8

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NOTE: Date & initial all entries

DART AEROSPACE LTD		Work Order:	44823
Description: Doubler		Part Number:	D3639-2
Inspection Dwg: D3639	Rev: A	Page 1 of 1	

FIRST ARTICLE INSPECTION CHECKLIST

☒ First Article ☐ Prototype

Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
Ø0.625	+0.008/-0.001	.624	x		V HB02	
Ø0.191	+0.005/-0.001	.190	x		V	
Ø0.098	+0.004/-0.001	.098	x		V	
0.69	+/-0.030	.69	x		V	
1.59	+/-0.030	1.584	x		V	
2.49	+/-0.030	2.490	x		V	
3.39	+/-0.030	3.391	x		V	
3.990	+/-0.010	3.990	x		V	
4.990	+/-0.010	4.991	x		V	
5.19	+/-0.030	5.193	x		V	
6.99	+/-0.030	6.99	o		V	
8.64	+/-0.030	8.649	x		V PRO HB02	
0.45	+/-0.030	.461	x		V	
0.710	+/-0.010	.710	x		V	
2.000	+/-0.010	1.999	x		V	
2.75	+/-0.030	2.758	o		V	
3.55	+/-0.030	3.554	x		V	
4.00	+/-0.030	4.007	x		V	
2.000	+/-0.010	2.000	x		V	
2.590	+/-0.010	2.590	x		V	

Measured by: <u>IB</u>	Audited by: <u>S</u>	Prototype Approval:	N/A
Date: <u>11-1-3</u>	Date: <u>11/01/03</u>	Date:	N/A

Rev	Date	Change	Revised by	Approved
A	07.10.19	New Issue	KJ/EC/DD	<u>IB</u>

W/O:		WORK ORDER CHANGES					
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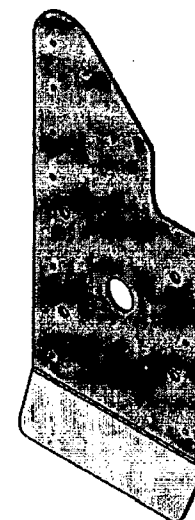
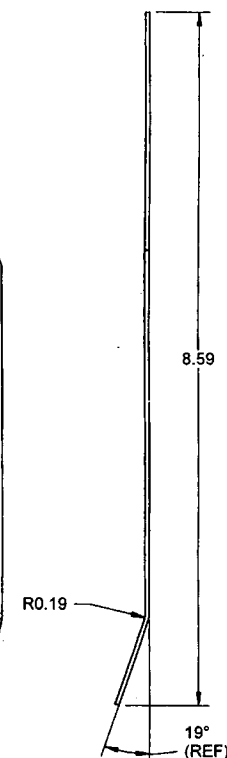
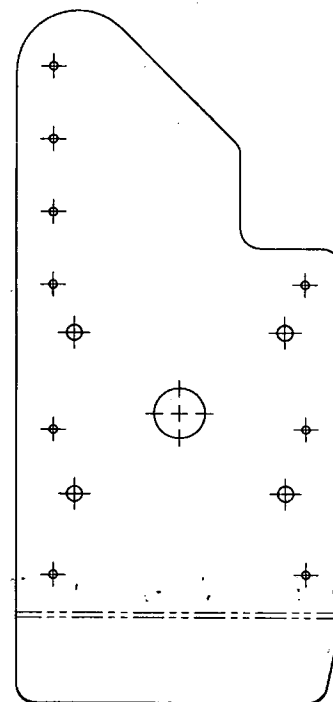
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NOTE: Date & initial all entries

Bl 1217



D3639-1 DOUBLER
(WAS GENEVA P/N G10604-3)
D3639-2 OPPOSITE
(WAS GENEVA P/N G10604-6)

RELEASE
07-29-07

- 1) MATERIAL: 2024-T3 ALUMINUM SHEET 0.050 THICK PER QQ-A-250/4 OR AMS 4037
(REF DART SPEC M2024T3S.050)
- 2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: IDENTIFY WITH DART P/N "D3639-1/2" USING FINE POINT PERMANENT INK MARKER
- 7) WEIGHT: 0.14 lbs

A	NEW ISSUE; REPLACES G10604	LE	07.07.27
REV.	DESCRIPTION	BY	DATE
DESIGN	TS	DART AEROSPACE USA, INC.	
DRAWN	CE	PORT HADLOCK, WA	
CHECKED	JB	DRAWING NO.	REV.
MFG. APPR.	FE	D3639	SHEET 1 OF
APPROVED	MD	TITLE	SCALE
DE APPR.	JA	DOUBLER	2:
DATE	07.07.27	COPYRIGHT © 2007 BY DART AEROSPACE USA, INC. THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL, AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE USA, INC.	

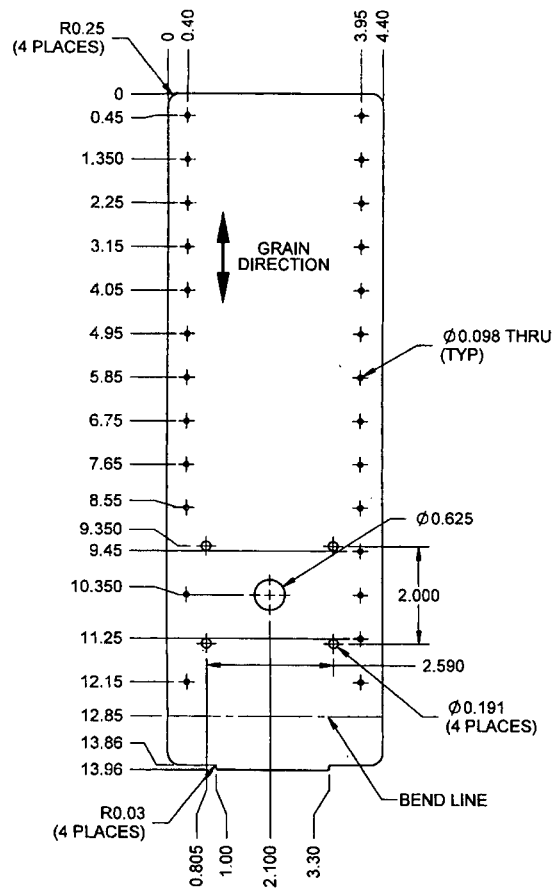
W/O:		WORK ORDER CHANGES					
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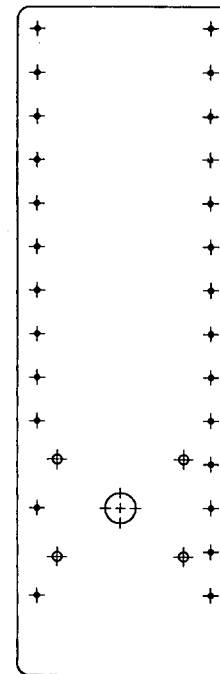
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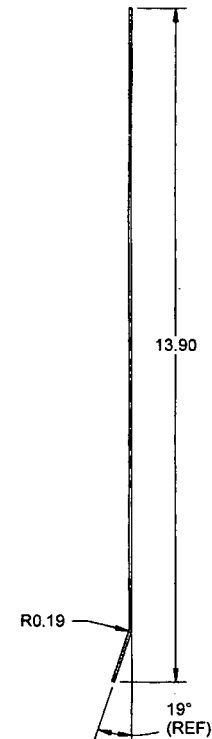


D3639-3F FLAT PATTERN
(D3639-4F OPPOSITE)

u/o 64823



D3639-3 DOUBLER
(WAS GENEVA P/N G10604-4)
D3639-4 OPPOSITE
(WAS GENEVA P/N G10604-5)



RELEASED
07.09.07

NOTES:

- 1) MATERIAL: 2024-T3 ALUMINUM SHEET 0.050 THICK PER QQ-A-250/4 OR AMS 4037 (REF DART SPEC M2024T3S.050)
- 2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: IDENTIFY WITH DART P/N "D3639-3/-4" USING FINE POINT PERMANENT INK MARKER
- 7) WEIGHT: 0.3 lbs

DESIGN	TS	DART AEROSPACE USA, INC.	
DRAWN	LE	PORT HADLOCK, WA	
CHECKED	JE	DRAWING NO.	REV. A
MFG. APPR.	JE	D3639	SHEET 2 OF 2
APPROVED	JE	TITLE	SCALE
DE APPR.	JE	DOUBLER	2:5
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